



**Criterii de acceptare a pieselor pentru trecere in  
cataforeza sau vopsitorie**  
*Acceptance criteria of the parts with cataphoresis or painting*

**1. Scop**

Aceasta fisa de instructaj are ca scop descrierea criteriilor de acceptare a pieselor in vederea trecerii acestora pe linia de tratare a suprafetelor si vopsitorie sau cataforeza.

**1. Purpose**

This instruction sheet aims to describe the acceptance criteria of the parts with cataphoresis or painting .

**2. Evidenta modificarilor/ Evidence of modifications**

Revision	Description change
0	Creating instruction sheet

Elaboration		Approval		
Name	Visa	Date	Name	Visa
G. ERBANUC	<i>Serbanuc</i>	10/01/17	. FLORIN	<i>FLORIN</i>

**3. Criterii de acceptare a pieselor pentru  
tratare vopsitorie sau cataforeza (lista  
non exhaustiva care se poate modifica  
fara preaviz) :**

Piesele brute **trebuie** :

- sa nu aiba niciun strop provenind de la sudura prin adaos de materii metalice ;
- sa nu fie impregnate cu un produs anti stropi ;
- sa nu prezinte urme de oxidare, de orice fel ar fi si oricat de mici ar fi ;
- sa nu fie impregnate cu nici un ulei nesolubil sau cu produse siliconice ;
- sa nu prezinte urme de mastic necompatibil cu vopseaua sau cataforeza ;
- sa nu fie vopsite, chiar si pe o suprafata minima si/sau care nu este vizibila ;
- sa nu fie impregnate cu produse pe baza de ceara (de tip anticoroziv) necompatibile cu vopseaua sau cataforeza ;
- sa nu prezinte bavuri i muchii ascu ite;
- sa nu prezinte calamina (piesele brute iesite de la decupare laser sau care au fost supuse unor operatiuni de sudura trebuie sa fie periate si/sau slefuite pana la obtinerea unei suprafete curate);
- sa nu prezinte corpuri straine (lemn, plastic, carton, scotch, nisip,...) care sa duca la o poluare iremediabila a bailor si la o degradare a pieselor in curs de tratare;

**3. Acceptance criteria of the parts for the  
painting or cataphoresis treatment (non-  
exhaustive list that can change without  
notice):**

The parts before treatmet **have to be**:

- without any drop welding;
- not be impregnate with anti-spot product;
- without oxidation marks and no matter the type and the size;
- without impregnation with any non-soluble oil or silicone products;
- without mastic incompatible with paint or cataphoresis;
- without paint, even on a minimum surface and/or which is not visible;
- without impregnation with wax-based products (anticorrosive type) incompatible with paint or cataphoresis;
- without burrs and sharp edges;
- without calamine (the raw parts from cutting laser or that were the subject to welding operations need to be brushed and/or polished until obtain the surface clean);
- without foreign materials (wood, plastic, cardboard, scotch, sand, ...) which would lead to an irremediable pollution bathrooms and a degradation of parts under treatment;

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**Criterii de acceptare a pieselor pentru trecere in cataforeza sau vopsitorie*****Acceptance criteria of the parts with cataphoresis or painting***

- sa nu prezinte suduri de tip TIG decat cu conditia acceptului nostru in urma efectuării unor teste interne;
- sa nu fie realizate in asa fel incat sa nu poata fi acrosate prin mijloacele de acrosare standard (piesele trebuie sa aiba cel putin doua gauri) ;
- sa nu fie realizate astfel incat sa nu permita evacuarea lichidelor infiltrate in partile concave in cursul diferitelor operatiuni de tratare a suprafetelor efectuate in timpul procesului de vopsire sau cataforeza;
- sa nu depaseasca capacitatile dimensionale ale liniei de cataforeza sau vopsire pudr .

In cazul receptiei materiei prime se vor urmari urmatoarele aspecte:

1. Tablele si teville sa nu prezinte urme de oxidare sau rugina pe suprafata.
2. Tablele si teville sa nu fie impregnate cu uleiuri nesolubile.
3. Tablele si teville sa nu prezinte zgarieturi profunde.

**4. Procesul de acceptare a pieselor pentru tratament vopsitorie sau cataforeza :**

Acceptarea pieselor in vederea unui tratament cataforeza in spatiile noastre, este oferita prin grija noastra cu conditia respectarii criteriilor enumerate mai sus si in functie de rezultatul testelor efectuate de catre Departamentele Metode si Calitate ale societatii noastre. Aceasta acceptare va ramane valabila atata timp cat toate criteriile vor fi respectate.

- without TIG welds, only under our acceptance after performing of the internal tests;
- the parts have to assure the hanging by standard hanging means (the parts must have at least two holes) ;
- the parts have to allow the discharging of liquids infiltrated in concave sides during the different surface treatment operations achieved during the painting powder or cataphoresis process;
- the dimension of parts don't exceed the dimensional capabilities of the cataphoresis line or painting powder.

In the case of the raw material reception it will pursue the following:

1. The sheets and tubes must to be without oxidation or rust marks on the surface.
2. The sheets and tubes must to be impregnated without insoluble oil.
3. The sheets and tubes must to be without deep scratches.

**4. Acceptance process of the parts for the painting or cataphoresis treatment**

Acceptance of the parts for cataphoresis treatment in our spaces, is provided by us only if the compliance criteria from above are assured and also is function the results of the tests performed by the Methods and Quality Department from our company. This acceptance will be valid as long as all criteria will be respected.

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